

Date Thursday, 16/08/2007 10:22:17 AM  
User Linda Lacelle

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACERS (1/4 THICK)
Job Number	: 33985		
Estimate Number	: 10247		
P.C. Number	: <i>NA</i>	Part Number	: D2022101
This Issue	: 16/08/2007 S.O. No. : <i>NA</i>	Drawing Number	: D2022 REV. --
Prsht Rev.	: NC	Project Number	: <i>NA</i>
First Issue	: <i>NA</i> Type : MACHINED PARTS	Drawing Revision	: <i>NA</i>
Previous Run	: 30543	Material	: <i>NA</i>
Written By	: <i>[Signature]</i>	Due Date	: 25/09/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	<i>404</i> Um: Each
Comment	: Est D 02.08.07 Now made in house NG		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0750	6061-T6 Round Bar .750"
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Comment: Qty.: 0.0329 f(s)/Unit Total: 13.1460 f(s)  
6061T6 Round Bar .750"  
Material: 6061-T6 (QQ-A-225/8)x.750Ø bar  
(M6061T6R0.750 Batch: *103156*

*13'*

*RD 07/11/04*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL  
1- Note: .257( F ) Dia drill  
2-Turn Blank as per FolioFA206  
3-Tumble & deburr any sharp edges as per dwg

*RD 07/11/04*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*RD 07/11/04*

*(404)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*8F 02/11/05*

*(404)*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: *ST.9*

*(404)*

*07/11/05*

*[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 07/11/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACERS (1/4 THICK)

Job Number: 33985

Part Number: D2022101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten: D2022101*

Job Completion



*Handwritten: U 07.11.05*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

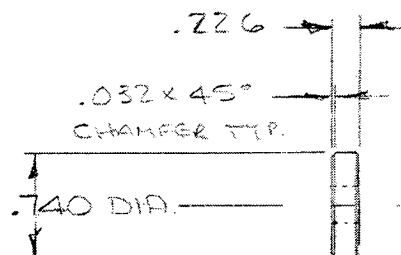
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

RELEASED  
770119 Bu



D2022-101  
D2022-103

DRILL 'F' (.257) DIA. IN -101  
DRILL P (.323) DIA IN -103

MAT'L: ALUMINUM 6061-T6 (QQ-A-225/B)



D2022

D2022-103	SPACER 5/16	ALUM 6061-T6	QQ-A-250/B
D2022-101	SPACER 1/4	ALUM 6061-T6	QQ-A-250/B

REVISION DRAWN APPROVED		THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		QTY REQUIRED		APPROVAL		CONTRACT NO. DART AERO ACCESSORIES INC			
DESCRIPTION OF CHANGE		REQUIREMENTS - UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE FINISHES - 100 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER MIL - 1.7742 5. HOLES PER AND 1.041		PARTS 1. TOLERANCES - .001 2. ANGLES - 45° 3. PARALLELISM - .002 4. ECCENTRICITY - .002 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005		BASIC CODES D - DASH NO R - HEAD NEAR SIDE P - HEAD FAR SIDE L - LENGTH DASH NO W - SHOTFIELD B - HATCHED TO INDICATE SHOTFIELD		DART AERO ACCESSORIES INC		DATE 10/1/83		CLIENT SPACERS	
REPORT ALL DISCREPANCIES - DO NOT SCALE		Dwg No D2022		SCALE 1:1		SHY 1 OF 1		REV.		REV.			

